

Date: Thursday, 8/24/2006 11:10:34 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: TOW RING
Job Number	: 28321		
Estimate Number	: 10794		
P.O. Number	: N/A	Part Number	: D3407041
This Issue	: 8/24/2006 S.O. No. : N/A	Drawing Number	: D3407 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Drawing Revision	: C
Previous Run	: 26503	Material	: N/A
Written By	: <u>JA 06/08/24</u>	Due Date	: 9/10/2006
Checked & Approved By	: <u>JA 06/08/24</u>	Qty:	12 Um: Each
Comment	: Est Rev: A 05.10.14 New issue KJ/EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D34071	Stem
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3407-1	Stem	<u>B28332</u>

JA 06/09/19 (11)

2.0	D34075	Ring
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3407-5	Ring	<u>B28512</u>

JA 06/09/19 (11)

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

Weld D3407-3/-5 using welding rod TIG174 as per Dwg D3407 & QSI 004

A/R TIG174 ROD Batch: M18774

JA 06/09/19 (11)

4.0	QC5/9	WELD INSPECTION
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Comment: WELD INSPECTION

PD 06-09-19 (11)

5.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Mask Threaded Section

Q.M 06-09-19 (11)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/09/21

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 8/24/2006 11:10:35 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TOW RING

Job Number: 28321

Part Number: D3407041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06 09 19 (11)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

st 434

Rec'd 06/09/20 (11)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

10 06/09/21 (11)

Job Completion



U 06/09/21

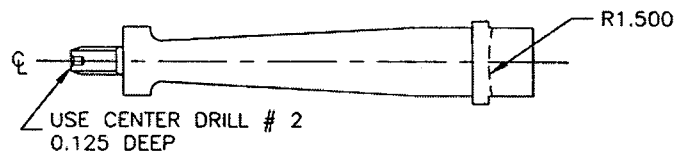
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

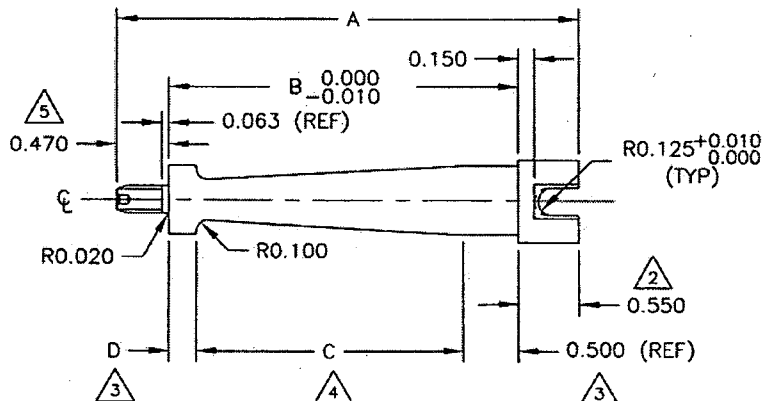
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



RELEASED

05.09.12



PART NUMBER	A	B	C	D
D3407-1	5.270	4.250	3.250	0.500
D3407-3	4.325	3.305	2.555	0.250

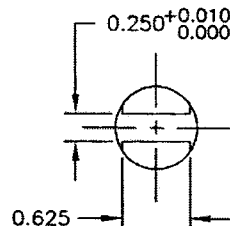
D3407-1/-3 STEM

D3407-1 AND D3407-3 STEM:

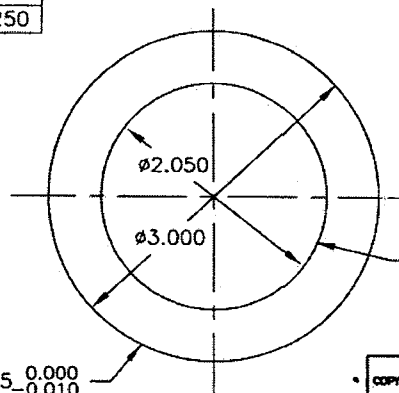
- 1) MATERIAL: 17-4 PH SS ROUND BAR (REF DART SPEC. M17-4-R0.750)
- 2) $\phi 0.750$ O.D.
- 3) $\phi 0.625$ O.D.
- 4) MACHINE UNIFORM TAPER FROM $\phi 0.363$ O.D. TO $\phi 0.625$ O.D.
- 5) 1/4-28 UNF THREAD WITH 0.063 GRIP, CLASS 2A
- 6) MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
- 7) UNLESS OTHERWISE INDICATED
- 8) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D3407-5 RING:

- 9) MATERIAL 17-4 PH SS ROUND BAR (REF DART SPEC. M17-4-R3.000)
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



USE D3407-1 STEM FOR -041
USE D3407-3 STEM FOR -043

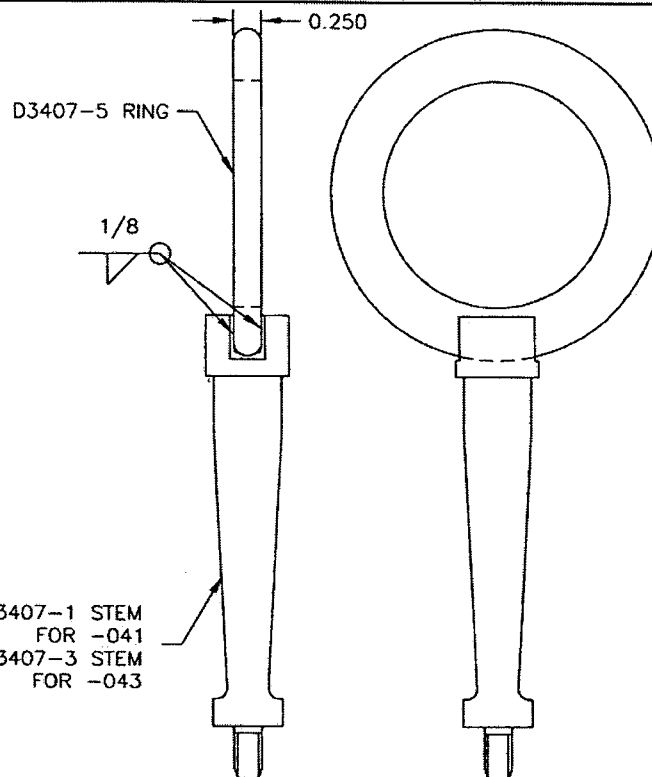


D3407-5 RING

DEBURR 0.010 TO 0.020

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D3407-041 AND D3407-043 TOW RING:

- 11) WELD PER QSI 004 ON ALL EDGES BETWEEN STEM AND RING
- 12) FINISH: POWDER COAT WHITE (REF 4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
- 14) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

C	05.09.09	-1/-3 LONGER FOR FIT W/ WASHER
B	05.06.17	UPDATE DIAMETER, THREAD CLASS ADDED
A	05.03.16	NEW ISSUE
DESIGN	CP	DRAWN BY CP
CHECKED	CP	APPROVED
DATE	05.09.09	DRAWING NO. D3407
		TITLE TOW RING
		REV. 0
		SHEET 1 OF 1
		SCALE 1:1

WORK ORDER
28321
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE